| Work Ord June-18-14 1:5 | | 1233 | | *12 | 1233* | | | | | | Page 1 |
|---|------------------------------------|---------------------------------|--|-------------------|--------------------------|------------|---|---------------|----------------|------------------|------------------|
| Item ID: Revision ID: | D3463-042 | | | Accept | *N900 | 040 | 100 | ገ* | Setup Sta | 17 | IS1* |
| Item Name: Start Date: Required Date: | Step Weldmen 6/18/14 6/18/14 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item I Customer: | D: | | | | * * \ | IS9* |
| Reference: Approvals: | | in: MLJ | Date: 1406-18 | Tooling: | | nte: | - - | 1 | Run Sta Sto | | IR1* |
| Sequence ID/ Work Center II | - | Operation Description | _ Date: | Set Up/ Run Hours | Da | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr D3463 | Rev Rev | ision Nbr B | | | | | *************************************** | | | 1,000,00 | - |
| 100 *1 \\ Large Fab Large Fab | | | bly as per dwg D3463 usin small none welded area on ** | | 63-3 step to . | | | 4 | Œ | 14-10-0 | 77 |
| 110 *1 1 1 * QC Quality Control | | QC9- Inspect visual per of Memo | QSI004- Fusion Welds | 0.00 | | | | <u> </u> | 14-10 |)- <u>99</u> | DAS 9 9-89 |

120

QC5- Inspect part completeness to step on W/O

0.00

Memo Quality Control

0.00

m.10.96

| DQA: | | | Date: | | | | | | | | | | | DART |
|---------------|--------|-----------|-------------|-------|----------|------------------------------|---|---------|--------------------|-----------|---------------|---------------|----------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON | -C(| ONFO | RMANCE / UF | | ork Order up | odate only | | AEROSPACE |
| Work Ord | or: | | | | | DISPOSITION | | | | AGAINST D | EPARTMENT, | /PROCESS | | |
| WOIK OIG | ٠. | | *** | | | Rework | 1 | | Skid-tube | Crosstube | | Water Jet | \neg | Engineering |
| Part I | No. | | | | | Scrap | | | Machining | Small Fab | Pro | d. Eng. Coor. | ᅦ | Quality |
| | • | | | · | | Use-as-is | | | noforming | Finishing | Rec/Sto | re/Packaging | | Other |
| NCR I | ۷o. | | | | | Suspected Unapproved |] | | Large Fab | Composite | | Supplier | | |
| Root | | | | | Desc | ription of work order update | | nitial | Acti | ion | Sign & | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descri | iption | Date | Verification | <u> </u> | QC Inspector |
| Design | | | | | | | | | | | | | | |
| Doc/Data | Щ | | | | | | | | | | | | l | |
| Equip/Tooling | Ш | | | | , | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Operator | Ш | | | | | | ļ | | | | | | | |
| Offset/Setup | | | ŀ | | | | 1 | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | |
| Training | Ш | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | ŀ | |
| Unapproved | | | <u> </u> | | <u> </u> | | <u> </u> | | <u> </u> | | | | | |
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| Landi | ng (| 1 | | | | General | | 1 . | | | - . | Г | _ | |
| | | Bending | | | | Bend | <u> </u> | 1 | Program | | Outside Dim | | | Pressure/Forced |
| | _ | Centre N | ot Concer | ntric | | BOM/Route | <u></u> | Grain | | <u> </u> | Over/Under | | _ | Set-up |
| | Ш | Cracks | | | <u> </u> | Broken/Damage/Defect | <u></u> | Hardwa | | ļ | Part Incorred | ŀ | | Temperature/Cure |
| | \Box | Crimp/Ki | nk/Ripple | /Wave | | Burrs | <u>_</u> | 4 | ion Incomplete/Un | <u> </u> | Part Lost/Mi | ssing | | Weld |
| | | Cuffs | | | <u> </u> | Contamination | | 4 | tions Incomplete/U | nclear | Part Moved | Į | | Wrong Stock Pulled |
| | | Crushing | | | | Countersink | | - | gned/off center | <u> </u> | Positioned V | r | | |
| | | Heat Trea | at | | | Cut Too Short | $ldsymbol{le}}}}}}$ | Mislabe | | L | Power Loss/ | Surge | (| Other |
| - | | Inspectio | n Strip in | Tube | | Drawing | | Misrea | | - | | | | |
| | | Marks/Cl | natter | | | Drill Holes | <u></u> | Off-set | | | | | | |
| | | Turning S | Sequence | | | Finish | | Out of | Calibration | | | | | |
| | | Wave/Tw | vist in Tub | e | | Fit/Function | | Out of | Sequence | | | | | |

| Work Orde June-18-14 1:5 | | 1233 | | *12 | 1233* | | | | | | | Page 2 |
|--|---------------------------|------------------------------------|---|---------------------|--------------------------|-------------|--------------|---------------|-------------|---------------|------------------|------------|
| Item ID: Revision ID: Item Name: | D3463-042 Step Weldmen | nt Assembly | | Accept | *N900 | 04 0 | 1100 | ገ* | Setup | Start Stop | | S1* S2* |
| Start Date: Required Date: Reference: | 6/18/14 6/18/14 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item I Customer: | D: | | | _ | G | | |
| Approvals: | Process Pla | ın: | Date: | Tooling: SPC (Y/N): | , | ate: | | | Run | Start Stop | | R1* R2* |
| Sequence ID/ Work Center II 130 *120* Powdercoat Powder Coating |) | START TIM | as indicated on dwg D346 IE: IPERATURE: 460 | | Tool ID | Tool # | Plan Code | Accept Qty | Rejo Qty | | Reject Number | Insp. |
| 140 *1 4 1 1 1 1 1 1 1 1 1 1 | | Wing Walk as per dwg (| 2SI005 4.4 Batch M \ 3 | ○ 256.po 0.00 | | | | <u>4 k</u> | | 4 | | 14/10/3 |

150

QC3- Inspect Part Finish

0.00

150 QC

Hand Finishing

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0.00

Quality Control

| DQA: | | _ Date: | | | | | | | | | | TOART |
|---------------|------------|-------------|----------|----------|------------------------------|--------------------|----------|-------------------|------------|---------------|---------------|--------------------|
| QA Closed: | | Date: | | | WORK ORDER NON- | -C(| ONFO | RMANCE / UF | | Vork Order uj | odate only | AEROSPACE |
| | | | | | DISPOSITION | | | | AGAINST D | EPARTMENT | /PROCESS | |
| Work Orde | r: | | | | 510. 50.11.511 | . | | | _ | | · | , , , , |
| | | | | | Rework | | | Skid-tube | Crosstube | _ | Water Jet | Engineering |
| Part N | 0 | | | | Scrap | | • | Machining | Small Fab | ┥ | d. Eng. Coor. | Quality |
| | | | | | Use-as-is | | i | noforming | Finishing | Rec/Sto | re/Packaging | Other |
| NCR N | lo | | | | Suspected Unapproved | | | Large Fab | Composite | | Supplier | |
| Root | | | <u> </u> | Desci | ription of work order update | | nitial | Acti | ion | Sign & | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | 1 | | | | | | | | | ĺ | |
| Handling/Pre | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Offset/Setup | | | | | | ĺ | | | • | | | |
| Process | | | | | | | | | | | | |
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| Training | | | | | | | | | | | | |
| Transport | , | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | |
| | | | | | | FAI | ULT CAT | EGORY | | | | |
| Landin | g Gear | | | _ | General | _ | | | | | | ۱ ا |
| - | Bending | | | | Bend | | 1 | rogram | _ | Outside Dim | | Pressure/Forced |
| - | Centre N | ot Conce | ntric | <u> </u> | BOM/Route | | Grain | | <u> </u> | Over/Under | | Set-up |
| _ | Cracks | | | | Broken/Damage/Defect | | Hardwa | | <u> </u> | Part Incorre | | Temperature/Cure |
| Ļ | Crimp/Ki | nk/Ripple | e/Wave | | Burrs | | 1 | on Incomplete/Un | _ | Part Lost/Mi | issing | Weld |
| L | Cuffs | | | | Contamination | | 4 | ions Incomplete/U | Inclear | Part Moved | | Wrong Stock Pulled |
| | Crushing | | | | Countersink | $oxedsymbol{oxed}$ | 1 " | ned/off center | <u> </u> _ | Positioned V | | ا ا |
| - | Heat Tre | | | | Cut Too Short | <u> </u> | Mislabe | | L | Power Loss/ | Surge | Other |
| <u>[</u> | Inspection | • | Tube | | Drawing | _ | Misread | I | | | | |
| | Marks/C | | | L | Drill Holes | | Off-set | | | | | |
| | | Sequence | | | Finish | | 1 | Calibration | | | | |
| | Wave/Tv | vist in Tul | эe | | Fit/Function | 1 | Out of 9 | Sequence | | | | |

| Work Or June-18-14 1 | | 21233 | , | *12 | 1233* | | | Page |
|---|------------------------------|------------------------------------|------------|----------|----------------------------|-------|---------------|----------------|
| Item ID: Revision ID: Item Name: | D3463-04 Step Weldn | 2 nent Assembly | | Accept | *N900040100* | Setup | Start Stop | *NS1* *NS2* |
| Start Date: Required Dat Reference: | 6/18/14 e: 6/18/14 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item ID: Customer: | | | |
| Approvals: | Process I | Plan: | Date: | Tooling: | Date: | Run | Start Stop | *NR1* |

SPC (Y/N):

Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Reject Insp. Work Center ID Description Qty Number Run Hours Code Qty Stamp 160 Identify as per dwg & Stock Location 0.00 *160* Packaging 0.00 Memo

Date:

170

QC21- Final Inspection - Work Order Release

Date:

0.00

170 QC

Packaging

Memo

QC:

0.00

Quality Control

1-11112 H

36 9-89

DAS

Page 3

| DQA: | | | Date: | | | | | | | | | | | DART |
|---------------|------------------|----------------------|-------------|------------|----------|------------------------------|----------|-----------|--------------------|-----------|--------------------------|---------------|---------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON | -C(| ONFO | RMANCE / UP | | Vork Order up | ndate only | | AEROSPACE |
| QA Closed. | | | Date. | | | | | | | - | ·· | | | |
| Work Orde | er: | | | | | DISPOSITION | | | | AGAINST D | EPARTMENT, | /PROCESS | | |
| | - | | | | | Rework | | | Skid-tube | Crosstube | 7 | Water Jet | \Box | Engineering |
| Part N | ١o. | | | | | Scrap | | 1 | Machining | Small Fab | Pro | d. Eng. Coor. | | Quality |
| | • | | | | | Use-as-is | | Thern | noforming | Finishing | Rec/Stor | e/Packaging | $\overline{}$ | Other |
| NCR N | ۱o. ₋ | | | | | Suspected Unapproved | | | Large Fab | Composite | _ | Supplier | | |
| Doot | 1 | | | | Dose | ription of work order update | Н | nitial | Actio | on | Sign & | | | |
| Root Cause | | Date | Step | Qty | Desc | or non-conformance | | ief Eng | Descri | | Date | Verificatio | n | QC Inspector |
| Design | \Box | Date | Step | Qty | | of non-comormance | <u> </u> | iici Liig | <u> </u> | ption | Dute | Vermoutio | | <u> </u> |
| Doc/Data | \dashv | | | | | | | | | | | | - 1 | |
| Equip/Tooling | | | | | | | ĺ | | | | | | ı | |
| Handling/Pre | | | | | | | | | | | | | ľ | |
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| Operator | | | | | | | | | | | | | | |
| Offset/Setup | \Box | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | - 132/ | | | | |
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| Landi | | | | | | General | | 1 | | | ٦ | • | | D /F |
| | - | Bending | | | | Bend | <u> </u> | 4 | rogram | <u> </u> | Outside Dim | | \vdash | Pressure/Forced |
| | _ | Centre No | ot Concer | ntric | \vdash | BOM/Route | <u> </u> | Grain | | - | Over/Under | | \vdash | Set-up |
| | - | Cracks | | | | Broken/Damage/Defect | | Hardwa | | <u> </u> | Part Incorred | | \vdash | Temperature/Cure |
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| | ${f}$ | Crushing | | | | Countersink | - | - | gned/off center | - | Positioned V Power Loss/ | | | Other |
| | \vdash | Heat Trea | | Tb | | Cut Too Short | | Mislabe | | L | rower Loss/: | ourge | Ш | Oulei |
| | | Inspectio | | rube | <u> </u> | Drawing Drill Holos | | Misread | | | | | | |
| | | Marks/Ch | | | - | Drill Holes Finish | \vdash | Off-set | Calibration | | | | | |
| | - | Turning S Wave/Tw | | | - | Fit/Function | \vdash | 4 | Sequence | | | . = | | |
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Picklist Print

June-18-14 1:57:21 PM

Work Order ID: 121233

121233

Parent Item:

D3463-042

Parent Item Name: Step Weldment Assembly

D3463-042

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| 238-806 | | Purchased | No | | | 100 | Each | 138.0000 | 2 | 8 | | | |
| *238-806* SS DOWEL PIN 1" LONG | | | | | | | | | ** | - Q | 14-10 | 27 | |
| | | | | Location | | Loc | <u>Oty</u> | Loc Code | | | | | |
| | | | | ST396 | | | 100 | | _ | | | | |
| | | | | | M127628 | | 100 | • | _ | | | | |
| | | | | WA002 | | | 38 | | | | | | |
| | | | | 7 | M120119 | | 38 | | _ | _8 | | | |
| D3453-3 | | Manufactured | No | | | 100 | Each | 17.0000 | 1 | 4 | | | |
| *D3453-3* | | | | | | | | | ** | EZ. | 14- | 10-27 | |
| | . / . | | | <u>Location</u> | * | Loc | <u>Oty</u> | Loc Code | | | | | |
| | X | 10211 X | 4- | WA002 | | | 17 | | | | | | |
| | * | | | | 115648 | | 16 | | _ | | | | |
| | . • | | | | 98933 | | 1 | | | | | | |
| D3453-5 | | Manufactured | No | | | 100 | Each | 46.0000 | 1 | 4 | | | |
| *D3453-5* | | | | | | | | | ** | <i>E</i> 2 | 14.10 | -27 | |
| | | | | Location | | Loc | <u>Qty</u> | Loc Code | | √ | | | |
| | | | | WA001 | | | 19 | | _ | | | | |
| | | | | : | 109132 | | 19 | | _ | | | | |
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| DQA: | | Date: | | | | | | | | | | DART |
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| QA Closed: | | Date: | | | WORK ORDER NON- | -C(| ONFO | RMANCE / UPDATE | W | ork Order up | odate only | AEROSPACE |
| 2, r c.103cu. | | Dute. | | | | | | 4.0.4.1 | | · · · · · · · · · · · · · · · · · · · | | |
| Work Orde | r: | | | | DISPOSITION | | | AGAII | וט וכא | PARTMENT | /PROCESS | |
| | | | | | , Rework | | | Skid-tube Crossto | ube 🗌 | | Water Jet | Engineering |
| Part N | o | | | | Scrap | | | Machining Small | Fab | Pro | d. Eng. Coor. | Quality |
| | | | | | Use-as-is | | Therr | noforming Finish | ning | Rec/Sto | re/Packaging | Other |
| NCR N | 0 | | | | Suspected Unapproved | | | Large Fab Compo | site |] | Supplier | |
| Root | | | | Desci | ription of work order update | نـــــــا ا | Initial | Action | | Sign & | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | nief Eng | Description | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | |
| quip/Tooling | | | | | | | | | | | | |
| landling/Pre | | | i | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | · · |
| raining | | | | <u> </u> | | | | | | | | |
| ransport | | | | , | | | | | | | | |
| Jnapproved | | <u> </u> | | | | | LILT CA | FCORY | | <u> </u> | | 1 |
| | - C | · | | | | FAI | ULI CA | TEGORY | | | | |
| Landin | | | | | General Bend | | احمانه ۱۰ | Program | | Outside Dim | onsions [| Pressure/Forced |
| - | Bending Centre No | at Conco | atric | - | BOM/Route | | Grain | Togram | - | Over/Under | | Set-up |
| - | Cracks | or conce | itric | - | Broken/Damage/Defect | ┝ | Hardwa | aro. | | Part Incorred | _ | Temperature/Cure |
| - | Crimp/Kir | k/Rinnle | /\ <i>M</i> >ve | \vdash | Burrs | | 4 | ion Incomplete/Unqualified | | Part Lost/Mi | ⊢ | Weld |
| | Cuffs | ik) Mppie | ., wave | | Contamination | - | 4 · | tions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled |
| - | Crushing | | | - | Countersink | \vdash | 4 | gned/off center | - | Positioned V | ـــــا Vrong | |
| - | Heat Trea | t | | | Cut Too Short | - | Mislabe | | | Power Loss/ | | Other |
| - | Inspection | | Tube | | Drawing | - | Misrea | | _ | | · L | |
| F | Marks/Ch | • | | | Drill Holes | 一 | Off-set | | | | | , , |
| - | Turning S | | | | Finish | _ | 4 | Calibration | | | | |
| ľ | Wave/Tw | | | - | Fit/Function | | Out of | Sequence | | | | |

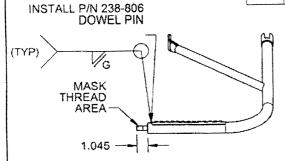
June-18-14 1:57:21 PM

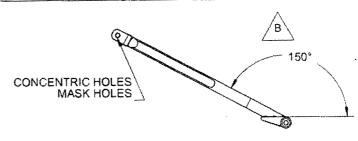
| Work Order ID: 121233 | | 21233* | | | | | | |
|---|-----------------|---------------------------------------|-----------|-----------------|-----------------|------------------------------|-----------------|---|
| Parent Item: D3463-042 Parent Item Name: Step Weldmer | nt Assembly | 3463-042* | | | | tart Date: 6 Start Qty: 4 | | Required Date: 6/18/14 Required Qty: 4.00 |
| D3463-1 *D3463-1* | Manufactured No | | 100 | Each | 1.0000 | 1 ** | 4 | 14-10-27 |
| | 121201 x4 | <u>Location</u> WA002 100985 | <u>Lo</u> | c Oty 1 1 | Loc Code | | | |
| D3463-3 *D3463-3* Step | Manufactured No | | 100 | Each | 9.0000 | 1 ** | 4 — <i>E</i> | 14-10:27 |
| ocp | 121236×4 | Location WA002 100938 103566 | Lo | 9 3 6 | <u>Loc Code</u> | | | |
| D3463-5 *D3463-5* End Cap | Manufactured No | 703300 | 100 | Each | 33.0000 | 2 ** | 8 A | 14-10-27 |
| | 121237x3 | UA002 WA002 97231 | <u>Lo</u> | 33 12 21 | Loc Code | | 5 | |
| 03463-7 * D3463-7* Orag Arm | Manufactured No | | 100 | Each | 3.0000 | 1 ** | 4 | 14/0-21 |
| | | <u>Location</u> WA002 103584 | <u>Lo</u> | 3 3 | Loc Code | | · · | |
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|---------------|----------|-------------|--------|----------|------------------------------|--|----------|----------------------------|----------|---------------|---------------|--------------------|
| QA Closed: | | Date: | | | WORK ORDER NON- | -C(| JNFO | RMANCE / UPDATE | W | ork Order up | odate only | AEROSPACE |
| Work Orde | | | | | DISPOSITION | | | AGAIN | ST DI | PARTMENT | /PROCESS | , |
| Work Orde | :I | | | | Rework | ı | | Skid-tube Crosstu | ٦ | 7 | Water Jet | Engineering |
| Part N | Jo | | | | Scrap | | | Machining Small F | | Pro | d. Eng. Coor. | Quality |
| rarer | | | | | Use-as-is | | | noforming Finishi | | | re/Packaging | Other |
| NCR N | lo | | | | Suspected Unapproved | | ,,,, | Large Fab Composi | - }- |] | Supplier | |
| Root | | 1 | | Desc | ription of work order update | | nitial | Action | | Sign & | | T |
| Cause | Date | Step | Qty | | or non-conformance | ı | ief Eng | Description | | Date | Verification | QC Inspector |
| Design | | <u> </u> | | | | | | | | | | |
| Doc/Data | ******* | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | 1 | | | | · |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Transport | | | | , | | | | | | | | |
| Unapproved | | | | | | | | | | | | |
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| Landi | ng Gear | | | _ | General | | | | _ | 7 | _ | -i |
| | Bending | ; | | | Bend | | 1 | Program | L | Outside Dim | | Pressure/Forced |
| | Centre I | Not Conce | ntric | | BOM/Route | | Grain | | \perp | Over/Under | _ | Set-up |
| | Cracks | | | | Broken/Damage/Defect | | Hardwa | | <u> </u> | Part Incorred | | Temperature/Cure |
| | | ink/Ripple | e/Wave | <u> </u> | Burrs | _ | 1 | ion Incomplete/Unqualified | <u> </u> | Part Lost/Mi | ssing | Weld |
| | Cuffs | | | | Contamination | | 1 | ions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled |
| | Crushin | | | <u> </u> | Countersink | | { | ned/off center | | Positioned V | | ٦ |
| | Heat Tr | | | <u> </u> | Cut Too Short | L | Mislabe | | L_ | Power Loss/ | Surge | Other |
| | | on Strip in | Tube | L | Drawing | L | Misrea | | | | | |
| | Marks/0 | Chatter | | | Drill Holes | $ldsymbol{ld}}}}}}$ | Off-set | | | | <u> </u> | |
| | | Sequence | | | Finish | <u> </u> | 1 | Calibration | | | | |
| | Wave/T | wist in Tul | be | | Fit/Function | | Out of : | Sequence | | | | |



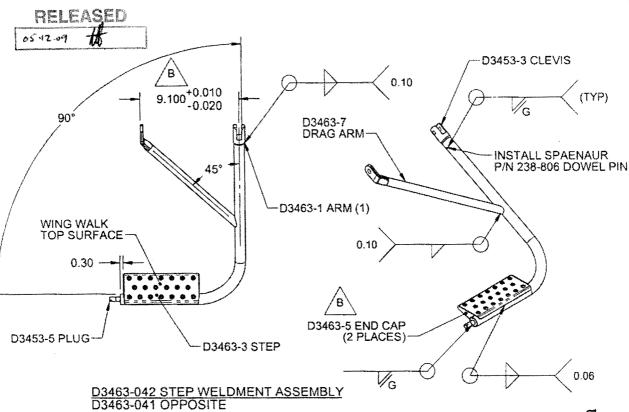
| DESIGN R | - | DRAWN BY RF | DART AEROSPAC HAWKESBURY, ONTARIO, | |
|-------------|------|----------------|---------------------------------------|--------------|
| CHECK | ED " | APPROVED [] | DRAWING NO. | REV. B |
| | M | 1 | D3463 | SHEET 1 OF 4 |
| DATE | | | TITLE | SCALE |
| | 05.1 | 12.05 | STEP WELDMENT | 1:8 |
| А | 0 | 5.09.20 | NEW ISSUE | |
| В | n | 5 12 05 | REVISE DIM.; D3463-5 WAS D34 | 463-5F |





UNCONTROLLED (*) SUBJECT TO AMENDA

WITHOUT NOTICE



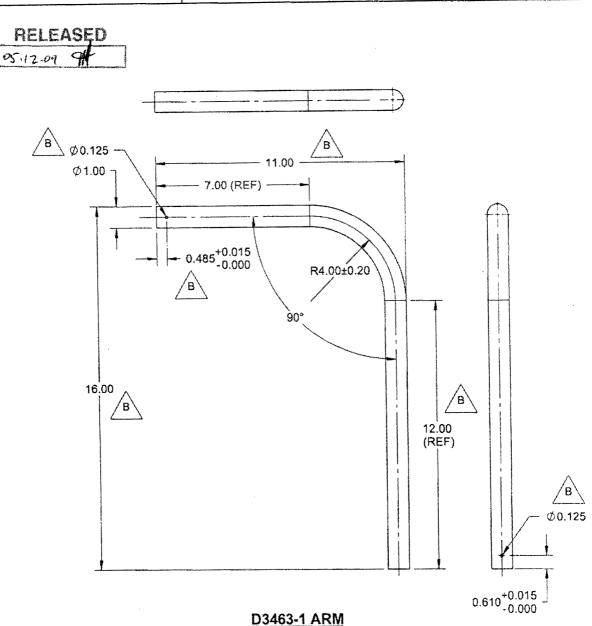
NOTES:

- 1) WELD PER DART QSI 004
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED Q4 ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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|--------------|----------------|------------------------------------|------------------------|
| CHECKED | APPROVED # | DRAWING NO. | REV. B SHEET 2 OF 4 |
| DATE 05.1 | 12.05 | STEP WELDMENT | SCALE 1:4 |



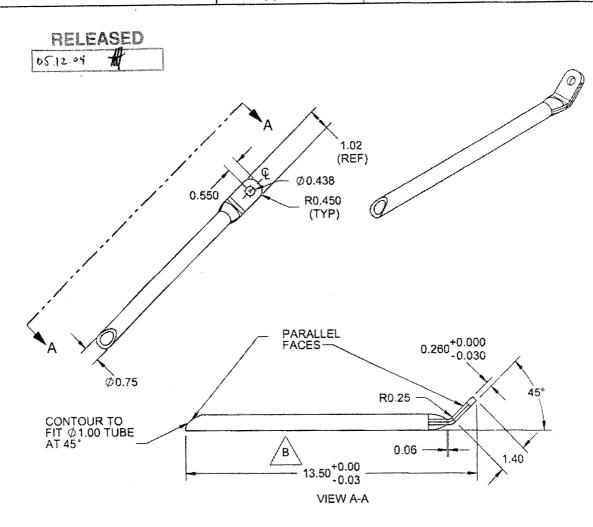
NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:4 |



D3463-7 DRAG ARM

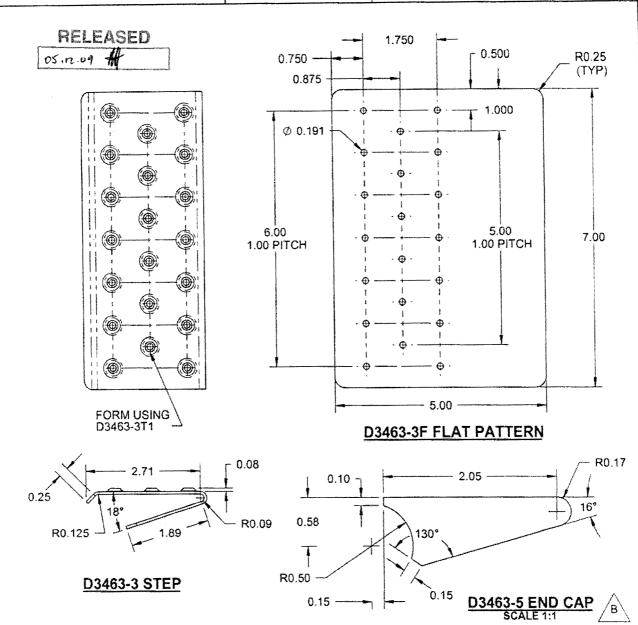
NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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| CHECKED # | APPROVED. | DRAWING NO. D3463 | REV. B SHEET 4 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:2 |



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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